

Work Order ID 62009



Page 1

Wednesday, September 15, 2010 9:56:58 AM

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 9/14/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-9-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

LA (10/09/27)

6 0

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: *AA*

DWG REV: *B*

LF 10/09/28

6 0

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date:	9/14/2010	Start Qty:	6.00			
Required Date:	9/21/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00				6	0		
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				6	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				6	0		

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Required Date: 9/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BL 10-10-4.

115291 START. 10:25
Memo QWENT. 320°
FINISH 10:55

0.00

6 0

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 1010101

Memo

0.00

6 0

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

10/14/4 (6)

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Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05 JD

u 10-10-05

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 9:57:02 AM

Page 1

Work Order ID: 62009



Parent Item: D3910-1



Parent Item Name: Crosstube Lug


Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	364.5171	0.13	0.821053			

Location

Loc Qty

Loc Code

MAT06

364.5170795

43722

180

45800

184.517079

0.8210 ft³ G.A 10/09/27

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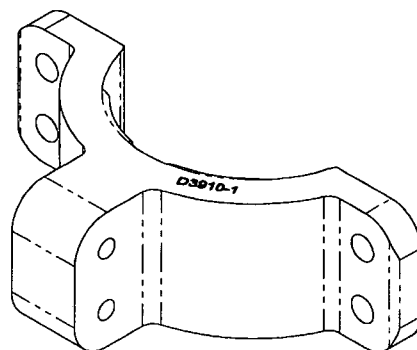
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

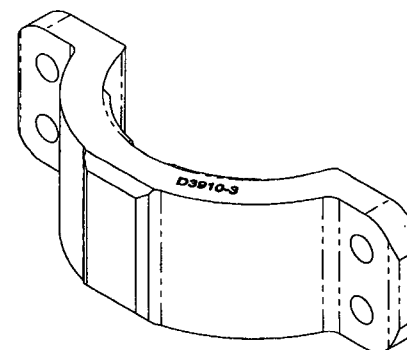
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W/O 62009



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED
2010-03-22
W/O

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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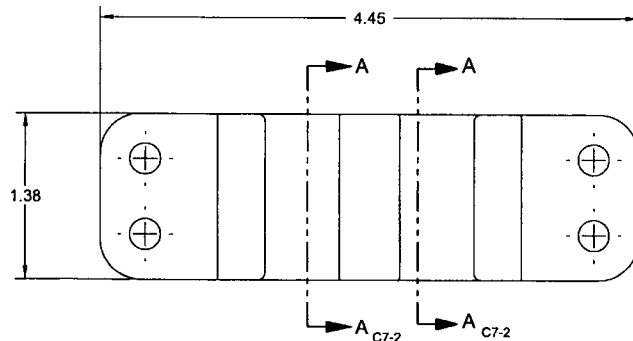
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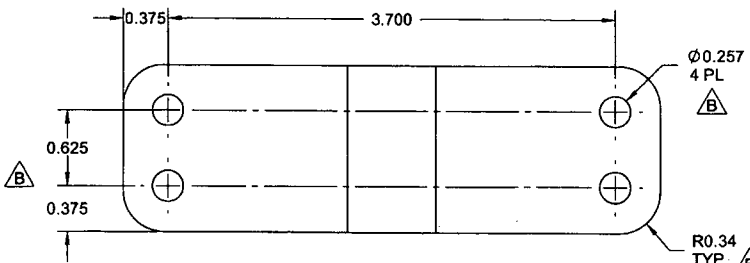
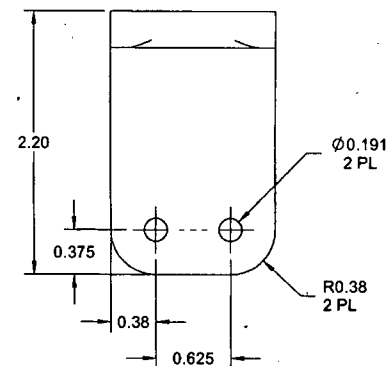
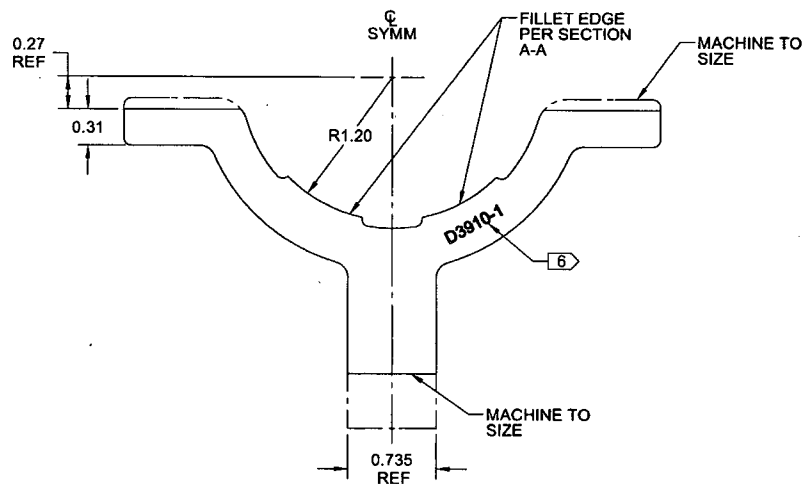


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



wlr 62009



D3910-1 X-TUBE LUG

RELEASED
2010-03-22
WLR

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	X-TUBE LUG (350)	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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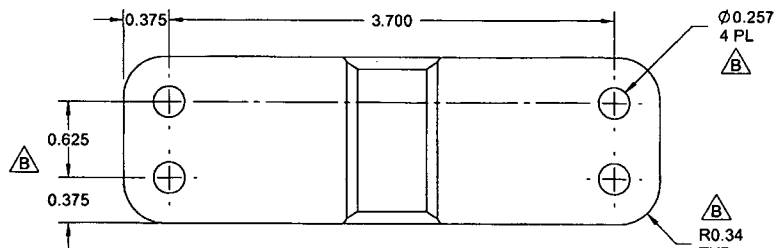
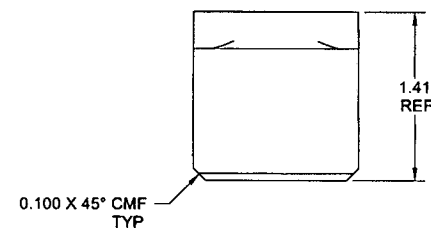
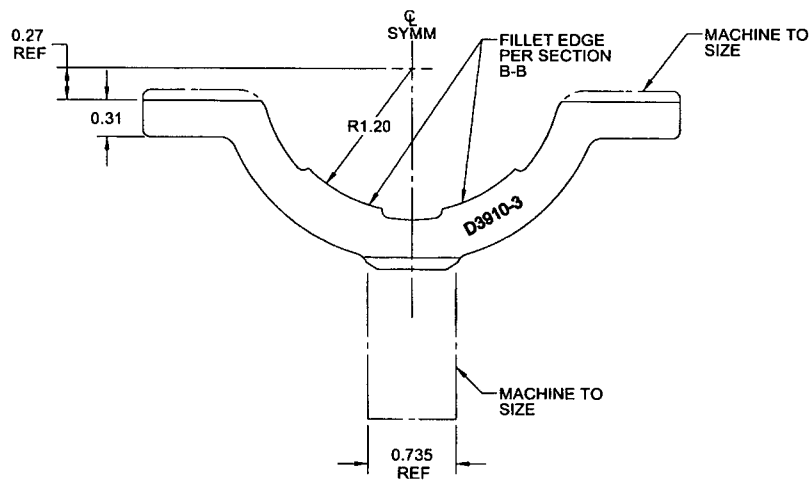
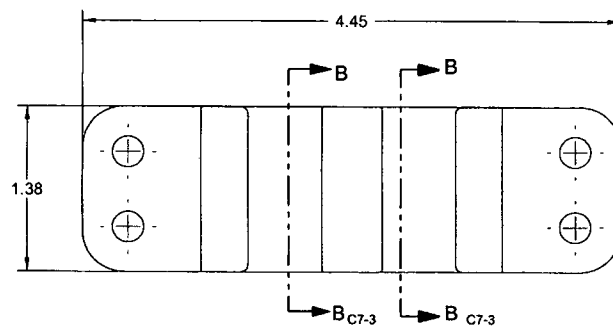
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

w/o 62009

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 3
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DE APPR.			NTS
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